

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015251**Date Inspected:** 24-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site

CWI Name:	Bernard Docena, Jesse Cayabyab			SWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A
Bridge No:	34-0006			Component:	SAS OBG	

Summary of Items Observed:

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process welding and inspection of the weld joints identified 4E/5E-C1, 2W/3W-C and the following observations were made:

4E/5E-C1

Upon the arrival of the QA Inspector it was observed ABF welder was setting up the flux cored arc welding (FCAW) machine to begin the FCAW root pass. The QA Inspector performed random visual testing of the fit up and noted it appeared to be in general compliance with the contract requirements. The QA Inspector randomly observed the ABF welder Song Tao Huang had previously started the induction heating blankets to ensure the minimum required preheat of 150°F was achieved prior to welding. The QA Inspector randomly verified utilizing a 150°F temperature indicating marker and noted the minimum required preheat had been achieved. The QA Inspector randomly observed the SE QC Inspector identified as Bernard Docena set the FCAW machine to the parameters of the approved WPS. The QA Inspector randomly observed the FCAW parameters were 240 Amps 23.8 Volts and a travel speed of 310mm/min. The QA Inspector randomly observed the ABF welder Song Toa Huang begin the FCAW root/fill pass of the top 900mm of the above identified weld joint by hand. The QA Inspector noted the FCAW parameters appeared to be in general compliance 3042-B-1. The QA Inspector noted the ABF welder spent the remainder of the shift performing the FCAW fill/cover pass.

2W/3W-C1/C2

The QA Inspector randomly observed the QC Inspector Tom Pasqualone monitoring the ABF welders James Zhen and Jin Quan Huang grinding and excavating the Ultrasonic testing (UT) rejections previously located and

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indicated. The QA Inspector noted the weld segment C1 appeared to have 3 UT rejections previously indicated by the QC Inspector Tom Pasqualone. The QA Inspector noted the weld segment C2 appeared to have 5 UT rejections previously indicated by the QC Inspector Tom Pasqualone. The QA Inspector noted no welding was performed on the QA Inspectors shift on this date. The QA Inspector observed only grinding was performed on today's date.

The QA Inspector Bert Madison was on site with the QA Inspector Rick Bettencourt in the AM for a brief tour and a run down of the nomenclature of the East and West bound bridge segments. The QA Inspector Bert Madison stayed in the field while the QA Inspector Rick Bettencourt spent the remainder of the shift researching and updating the ABF production welding tracking chart and logbook.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
